



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4034-043
Job Sheet 186281



Part No: D4034-043

Job Qty: 4 ea

Part Name: Fwd Upper Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEETS 1,2 IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA
10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER
DWG REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Large Fab-6		
100	Large Fab	4 pcs	12/7/18	12/7/18	0.00	3.25	Large Fab 1		
110	QC	4 pcs	12/7/18	12/7/18	0.00	0.00	QC9		
120	QC	4 pcs	12/7/18	12/7/18	0.00	0.00	QC5		
130	Packaging	4 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3 Large Fab		
140	QC21-SA	4 Ea	12/7/18	12/7/18	0.00	0.00	QC21		

Part Op 100 - 1- Assemble ribs to hoop and weld as per dwg DT9564 2- Weld bushing in rib as per dwg
Descriptions: 130 - LOCATION: WA004

DAS
21
9-89

NOV 29 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4021-7	Hoop	4 Ea (1 ea)	90-Start up Operation	511317520 5117 97520
D4021-9	Bushing	16 Ea (4 ea)	90-Start up Operation	5115 312
D4034-1	Rib	4 Ea (1 ea)	90-Start up Operation	5124 909
D4034-3	Rib	4 Ea (1 ea)	90-Start up Operation	5115 420

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4021-7	4	11	0
	D4021-9	16	517	0
	D4034-1	4	8	0
	D4034-3	4	14	0



Container No: S132095

Part: D4034-043

Job No: 186281

Serial No/Batch: S132095

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Specifications

Specifications could not be found.

Plex 11/13/18 3:09 PM Dart.lajeunesse.marie

Date: 11/28/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube</td> <td style="width: 15%;">Cross tube</td> <td style="width: 15%;">Water Jet</td> <td style="width: 15%;">Engineering</td> </tr> <tr> <td>Machining</td> <td>Small Fab</td> <td>Prod. Eng. Coord.</td> <td>Quality</td> </tr> <tr> <td>Thermoforming</td> <td>Finishing</td> <td>Rec/Store/Packaging</td> <td>Other</td> </tr> <tr> <td>Large Fab</td> <td>Composite</td> <td>Supplier</td> <td></td> </tr> </table>						Skid-tube	Cross tube	Water Jet	Engineering	Machining	Small Fab	Prod. Eng. Coord.	Quality	Thermoforming	Finishing	Rec/Store/Packaging	Other	Large Fab	Composite	Supplier	
Skid-tube	Cross tube	Water Jet	Engineering																						
Machining	Small Fab	Prod. Eng. Coord.	Quality																						
Thermoforming	Finishing	Rec/Store/Packaging	Other																						
Large Fab	Composite	Supplier																							
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By _____																		
							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐														
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐														
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐														
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐														
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐														
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐														
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐														
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐														
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐														
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐														
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____																					
Misidentified	☐	Past Due	☐																						